

Work Order ID 149620

Monday, July 25, 2016 2:38:53 PM

149620

Page 1

Item ID: D3705-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Instrument Paney Assy
Start Date: 8/17/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/19/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: AUG 03 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3705	E								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.10							
Small Fab	1- Assemble parts as per dwg D3705								
									<u>1</u> <u>Pc</u> <u>1</u> <u>FF</u> <u>AUG 2 2 2016</u>
									<u>AUG 2 4 2016</u>
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									<u>1</u> <u>AUG 2 4 2016</u>
									<u>DAS 38 9-89</u>
120	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									<u>DAS 6 9-89</u> <u>AUG 2 5 2016</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Item ID: D3705-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Instrument Paney Assy

Start Date: 8/17/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/19/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.02

Quality Control

DAS
21
9-89

AUG 2 5 2016

DAS
21
9-89

AUG 2 5 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE.

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
BAC FS 05-0 BAC FS 05-0				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 149620

149620

Parent Item: D3705-041

D3705-041

Parent Item Name: Instrument Paney Assy

Start Date: 8/17/2016

Required Date: 8/19/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-05-30 DD verified by:ec
IPP rev:B 09-01-09 rev.C as per dwg DD verified by:ec
IPP Rev:C 09-01-15 rivet chg DD verified by:EC IPP rev:D
10.04.21 washer chg per NCR10-017 DD verified by:EC
IPP Rev:E as per dwg RevD DD 10.04.27 verified by:EC IPP REV:F
12.12.03 REV PE1 DD VERF:JLM IPP REV:G 13.01.15
AS PER DWG REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3335-1 Short Spring		Manufactured	No			100	Each	122.0000	1	1			
D3335-1													
FF AUG 23 2016													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
GA 122													
110387 110													
83600 12													
D3705-043 Instrument Panel Weldment		Manufactured	No			100	Each	0.0000	1	1			
D3705-043													
FF AUG 23 2016													
D3705-5 Access Panel		Manufactured	No			100	Each	15.0000	1	1			
D3705-5													
PC													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
st507 15													
144546 15													
D3706-041 Lock Bracket Assembly		Manufactured	No			100	Each	0.0000	1	1			
D3706-041													
FF AUG 23 2016													

AUG 22 2016

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ -Other ☐					
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Parent Item: D3705-041

D3705-041

Parent Item Name: Instrument Paney Assy

Start Date: 8/17/2016

Required Date: 8/19/2016

Start Qty: 1.00

Required Qty: 1.00

D3706-5 Manufactured No 100 Each 15.0000 1 1

D3706-5

Pin

PC

Location

Loc Qty

Loc Code

ST052

15

109136

5

109912

10

1

D3707-3 Manufactured No 100 Each 8.0000 2 2

D3707-3

Mounting Lug

PC

Location

Loc Qty

Loc Code

ST052

8

139465

2

148354

6

2

AN3-3A Purchased No 100 Each 92.0000 2 2

AN3-3A

Bolt

PC

Location

Loc Qty

Loc Code

ST350

92

m134738

24

m135274

68

2

AN526C1032R6 Purchased No 100 Each 320.0000 4 4

AN526C1032R6

Screw

PC

Location

Loc Qty

Loc Code

ST327

320

1892

320

4

AUG 22 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec./Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Work Order ID: 149620

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Parent Item: D3705-041

D3705-041

Parent Item Name: Instrument Paney Assy

Start Date: 8/17/2016

Required Date: 8/19/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

100

Each

1,038.000

1

1

NAS1149D0563.J

Washer

PC

Location

Loc Qty

Loc Code

GA

199

m125807

2

m133769

197

ST263

740

m134497

4

m135058

736

ST269

99

m128257

99

CR1122-3-02.5

Purchased

No

100

Each

501.0000

28

28

CR1122-3-02 5

RIVET

FF AUG 2 3 2016

Location

Loc Qty

Loc Code

GA

425

m132708

25

m135297

400

ST321

76

m134612

32

m134861

44

MS171498

Purchased

No

100

Each

17.0000

1

1

MS171498

Spring Pin

PC

Location

Loc Qty

Loc Code

ST315

17

108521

17

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DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

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Work Order ID: 149620

Parent Item: D3705-041

Parent Item Name: Instrument Paney Assy

149620

D3705-041

Start Date: 8/17/2016

Required Date: 8/19/2016

Start Qty: 1.00

Required Qty: 1.00

MS21075L3 MS21075L3N Purchased No

100 Each 28.0000 14

MS21075L3

Nut Plate

**

14
X M129513 PC

Location

Loc Qty

Loc Code

GA

28

m134257

28

MS24693-C272

Purchased No

100 Each 1,018.000 4

MS24693-C272

Screw

**

PC

Location

Loc Qty

Loc Code

OVER010

986

17137

467

17831

519

ST287

32

9370

32

NAS1149D0332J

Purchased No

100 Each 1,614.000 2

NAS1149D0332J

Washer

**

PC

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

546

m134848

546

GA

979

m135046

979

ST264

83

m134502

6

m134738

77

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Description Work Order Deviation		Disposition		Completed By	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					